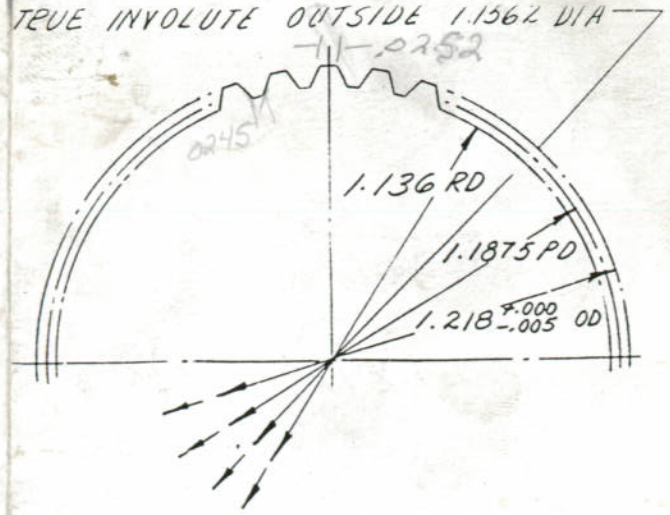
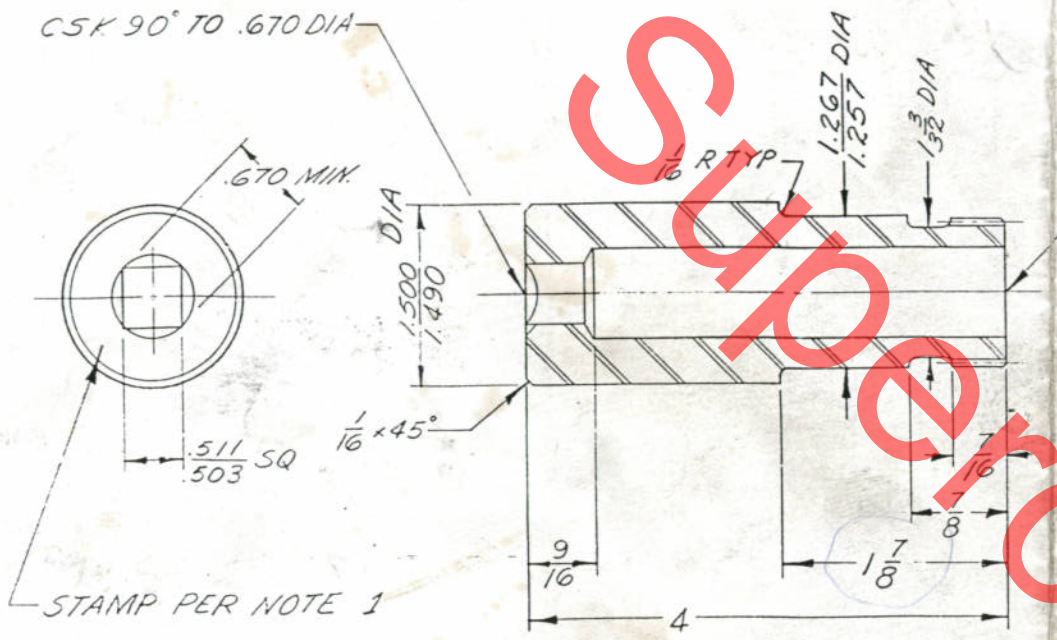
MUST BE TRUE INVOLUTE OUTSIDE 1.1362 DIA

EXTERNAL SPLINE DATA
32/64 PITCH 38 TEETH
30° PRESSURE ANGLE
ARC TOOTH THICKNESS AT PD = .0441 +.0000 -.0020
DIM OVER TWO .0540 PINS = 1.2556 +.0000 -.0023
BASE CIRCLE DIA = 1.0284

38 TEETH
38 GROOVES
9.4736842° DEGREES



SPLINE 4 x SIZE



SAE 4130 HDN 32-36 Rc

NOTES:

1. METAL STAMP IN LOCATION SHOWN WITH 1/8 - 3/16 HIGH FIGURES AS FOLLOWS:
   a) TOOL NO. & LAST CHG LTR PRECEDED BY WORD "ALLISON"
   b) VENDORS NAME OR TRADEMARK
2. ~~CADMIUM PLATE PER AMS 2400~~
   ~~DIMS. MUST BE MET AFTER PLATING~~
   black oxide 8/9/16

These tool drawings are furnished in accord with the terms of the DDA Tools Release Agreement. The aperture cards or drawings are to be maintained in the custody of the recipient and shall not be disclosed to any third party without specific written consent of Detroit Diesel Allison Division of GMC.

SPECIAL INSPECTION AND TEST REQUIREMENTS

~~WHEN PART OR ASSEMBLY REQUIRES MAGNETIC AND/OR FLUORESCENT PENETRANT INSPECTION, THERE MUST BE GOVERNMENT CERTIFIED OPERATORS AND INSPECTORS. WHEN PART OR ASSEMBLY REQUIRES WELDING, OPERATORS AND EQUIPMENT MUST BE GOVERNMENT CERTIFIED. IN ADDITION FACILITIES HAVING GOVERNMENT SOURCE INSPECTION MUST HAVE GOVERNMENT APPROVAL OF X-RAY, HEAT TREATMENT, ANODIZING AND PLATING EQUIPMENT WHERE APPLICABLE.~~

ALL PARTS, OTHER THAN EXPERIMENTAL, MANUFACTURED OR PROCURED TO THIS DRAWING INCLUDING REPLACEMENT SPARES, ARE SUBJECT TO QUALITY CONTROL PER SPECIFICATION MIL-Q-9858 AND USAF SPEC NOTICES THERETO, AND TO TESTING PER SPECIFICATIONS AND BULLETINS GOVERNING THE QUALIFICATION, APPROVAL AND RELIABILITY OF ALLISON PRODUCTS. MRB PROCEDURES MUST INCLUDE PARTICIPATION BY ALLISON ENGINEERING AND QUALITY CONTROL REPRESENTATIVES UNLESS OTHERWISE AUTHORIZED BY ALLISON.

USED ON ENGINE MODELS
T63-A-5 YT63-A-5

LTR	DESCRIPTION	DATE	APPROVAL

CONTROLLED DOCUMENT
AUG 03 2016
JOB NUMBER
01-5052

6795984
SHT 1 OF 1

11-06-13
RELEASED FOR PROD.
DATE: 9/1/06 INT: Dew
1/7/08 BR
04-25-13

AMS 2400	
NUMBER	
SPEC SUMMARY (REF.)	

UNLESS OTHERWISE SPECIFIED BREAK SHARP EDGES	1/32	APPROVALS	DATE
TOL. ON ANGLES ±	1°		
TOL. ON THREE PLACE DECIMALS ±	.010		
TOL. ON FRACTIONS ±	1/64		
FOUR-PLACE DECIMAL DIMENSIONS WITHOUT TOLERANCES ARE BASIC			
MATL. SEE DET		DRAWN SHAY	6-21-62
HEAT TREAT SEE DET		CHECKED WAG	6-22-62
WELD OR BRAZE		CHF. DR. GMT	6-22-62
SURFACE TREATMENT NOTED	INSPECTION	METALLURGY	
		ENGR. 1 JHH	6-22-62
		ENGR. 2 EJK	7-6-62
		ENGR. 3 DMS	7-9-62
		FINAL RH	7-10-62
		REVIEW APPROVAL	

ALLISON DIVISION
GENERAL MOTORS CORPORATION
INDIANAPOLIS, INDIANA

TITLE: HOLDER - POWER TURBINE SHAFT

MODEL

CODE	SIZE	DWG. NO.
73342	C	6795984

SCALE FULL & NOTED SHEET SHT 1 OF 1

FORM 882C (REV. 2-61)

Superceded.
SHOP COPY